

Date: Wednesday, 6/6/2007 3:04:21 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|----------------------------------------------------|----------------|------------------|--------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : CONSOLE BRACKET (206I) | |
| Job Number | : 32820 | | | | |
| Estimate Number | : 11007 | | | | |
| P.O. Number | : N/A | | Part Number | : D2607 | |
| This Issue | : 6/6/2007 | S.O. No. : N/A | Drawing Number | : D2607 REV A1 | |
| Prsh Rev. | : NC | | Project Number | : N/A | |
| First Issue | : N/A | | Drawing Revision | : A1 | |
| Previous Run | : 25473 | | Material | : N/A | |
| Written By | | | Due Date | : 6/30/2007 | |
| Checked & Approved By | | | Qty: | 30 | |
| Comment | : Est. E 02.06.05 Added alodine finish TSR 1290 NG | | Um: | /6 Each | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet |
| | | |
| | Comment: Qty.: 0.1313 sf(s)/Unit Total : 0.7875 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick Stack of 10 (M2024T3S.040) Batch <u>m105225</u> <u>IR 07-09-21</u> | (35) |
| 2.0 | SHEAR | SHEAR |
| | | |
| | Comment: SHEAR Cut Blanks 1.891 X 9.03 (Grain along 9.03, offset 10°) | <u>IR 07-09-21</u> |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| | | |
| | Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2607 | <u>N/A</u> |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | <u>IR 07-09-21</u> |
| 5.0 | QC8 | SECOND CHECK |
| | | |
| | Comment: SECOND CHECK | <u>IR 07-09-21</u> <u>(X35)</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 9/14/09
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:04:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (206)

Job Number: 32820

Part Number: D2607

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2607

SB 07/11/07 (35)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(cont'd)
07/11/07 (35)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(cont'd)
07/11/08 (35)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FY 07/11/08 (35)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 42

(overstock)

18 07/11/08

CO

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(35)

Comment: FINAL INSPECTION/W/O RELEASE

1 Daily/07

Job Completion



U 07/11/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 32820 |
| Description: Console Bracket | Part Number: | D2607 |
| Inspection Dwg: D2607 | Rev: A1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | B | Audited by: | C | Prototype Approval: | N/A |
| Date: | 07-09-21 | Date: | 07/09/24 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 05.02.17 | New Issue | KJ/JLM | [Signature] |

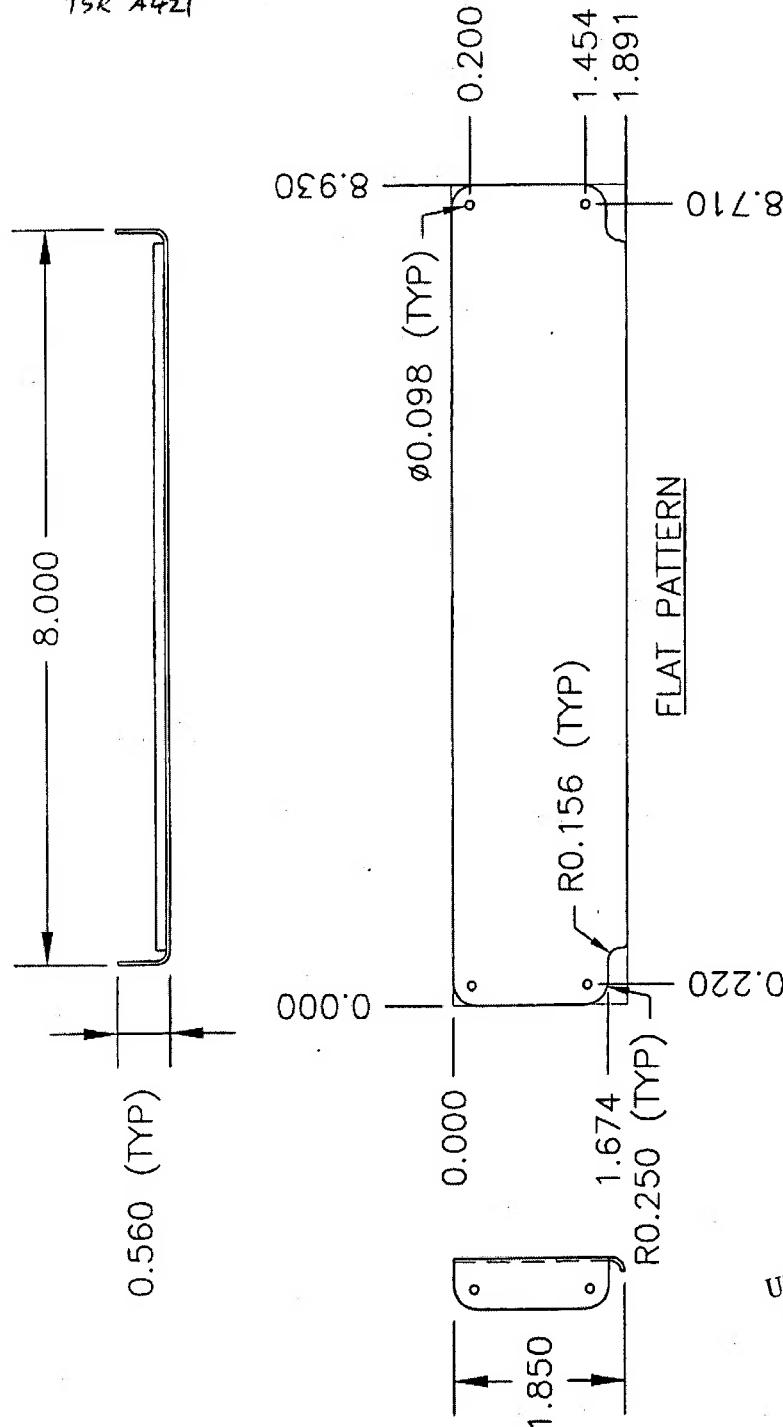
DART

| | | | |
|----------------------|-----------------------|--------------------------------------------------------------|------------------------|
| DESIGN <i>J</i> | DRAWN BY <i>BW</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>SJ</i> | DRAWING NO. D2607 | REV. A SHEET 1 OF 1 |
| DATE 97.10.23 | | TITLE CONSOLE BRACKET | SCALE 1:2 |
| A | 97.10.23 | D2607 WAS D206-547-9 | |
| A1 | <i>IRB</i> 02.06.04 | ADD FINISH | |

RELEASED

97.11.04 KE

TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32820

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2607
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 A1